

Date: Tuesday, 31/03/2009 1:04:22 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 46737	
Estimate Number : 10518	
P.O. Number :	Part Number : D28063
This Issue : 31/03/2009 S.O. No. :	Drawing Number : D2806 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 42175	Material :
Written By :	Due Date : 07/04/2009 Qty: 40 Um: Each
Checked & Approved By : <u>JUL 09.03.31</u>	
Comment : Est:B 05.03.11 Part now turned KJ/JLM Est Rev:C Now on Doosan Lathe JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6H1000	6061-T6 HexBar 1.00
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Comment: Qty.: 0.0962 f(s)/Unit Total : 3.8472 f(s) $(.750 \times 40) \div 12 = 2.5 H$
 6061-T6 Hex Bar 1.0"
 Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.00" Hex Bar
 (M6061T6H1.000) Batch: 21109478 09/04/01

2.0	DOOSAN LATHE	DOOSAN LATHE
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**Comment:** Doosan Lathe1- Turn as per Folio FA105 Rev: N/A & Dwg D2806 Rev: A

2-Deburr per dwg D2806

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 46737

Part Number: D28063

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



40

Comment: INSPECT ALODINE

FL 09/04/02

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 48 ST

SS 09/04/02

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/02

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-04-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46751
Description: Bushing		Part Number: D2806-3
Inspection Dwg: D2806 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.000	/			
1.155	+/-0.010	1.140	/			STK. SIZE
0.250	+/-0.010	.250	/			
0.063 x 45°	+/-0.010	.063 x 45°	/			
0.080 x 45°	+/-0.010	.075 x 45°	/			
0.495	+0.000/-0.005	.495	/			
0.750	+0.000/-0.005	.748	/			
Ø0.316	+0.005/-0.000	.320	/			
0.094	+/-0.005	.090	/			

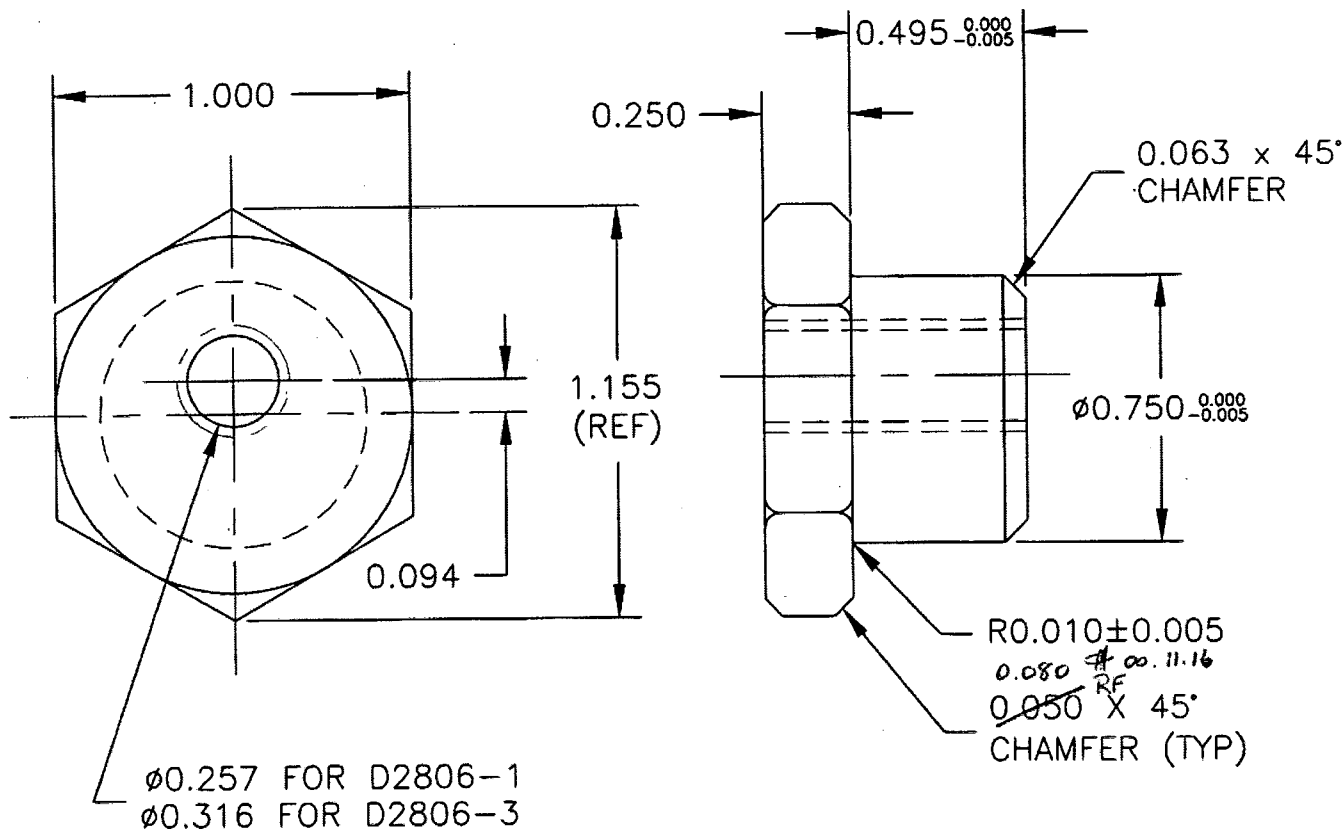
Measured by: [Signature]	Audited by: [Signature]	Prototype Approval:	N/A
Date: 09/04/01	Date: 09/04/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	
B	08.11.27	0.094 dimension added	KJ/EC [Signature]	[Signature]



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2806	REV. A SHEET 1 OF 1
DATE 00.11.08		TITLE BUSHING	SCALE 2:1
A	00.11.08	NEW ISSUE	

RELEASED
00.11.13 *[Signature]*



D2806-1 (DRILL $\phi 0.257$ HOLE)
D2806-3 (DRILL $\phi 0.316$ HOLE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46137

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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